

Work Order ID 54964

January 5, 2010 11:19:26 AM



Page 1

Item ID: D3562-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Assembly, RH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *RL*

Date: 10-1-05 Tooling:

Date:

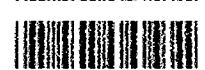
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3562	Rev E

100 Large Fab 0.00



Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion as per Dwg D3562 12-Deburr and bevel ends for welding

10.01.13

1

110 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

27 8.10.13

(H)

120 Chemical Conversion Coat per QS1005 4.1 0.00



HandFinish

Memo

0.00

Hand Finishing

10.01.14

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

3AD
10-01-15

①

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- Drill Rivet holes as per dwg D3562. Touch up alodine. 2- Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnobond ***** □A/R Magnabond 6398 Batch: ~~m11247~~

m11247

10-01-15

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

10-01-15

Quality Control

ARM

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals:

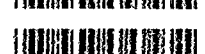
Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. 1A/Aluminum Rod mill 311 2-Grind end cap welds flush as per Dwg D3562

10-01-13

1

0

170



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

1

BE 10/01/13

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8 10/02/01

41

W/O:		WORK ORDER CHANGES					
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Start Date: 05/01/2010 Start Qty: 1.00



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Customer

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> ll

10-01-05

(X) 190

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

11113170

=> ll

10-01-05

(X) 190

START TIME:

7:15am

OVEN TEMPERATURE:

7:45am FINISH TIME:

320°C

210

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Wing Walk

Batch: 1113170

10-02-09

(X) 190

10/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

230

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/18

MF
10-2-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 54964

Parent Item: D3562-042

Parent Item Name: Step Assembly, RH

Comments:

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2734 Manufactured No



Step End Plate

100 Each 25.0000 2.0000



10-01-18

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 25

43535 2

48110 23

D2622-120C Manufactured No



Step Extrusion

140 Each 84.8200 1.0000



10-01-13

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA 84.82

48612 3.12

52026 81.7

D3560-042 Manufactured No



Arm Weldment

140 Each 3.0000 1.0000



10-01-13

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 3

47864 3

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

January 5, 2010 11:19:30 AM

Work Order ID: 54964



Parent Item: D3562-042



Parent Item Name: Step Assembly, RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3560-044		Manufactured	No			140	Each	5.0000	1.0000			
Arm Weldment												

12 10.01.13

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
46403	1	
<u>47866</u>	4	

MS20600-AD4W5	Purchased	No				160	Each	852.0000	32.0000			
Blind Rivet												

12 10.01.18

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	852	
110523	212	
<u>111477</u>	640	

32

W/O:		WORK ORDER CHANGES					
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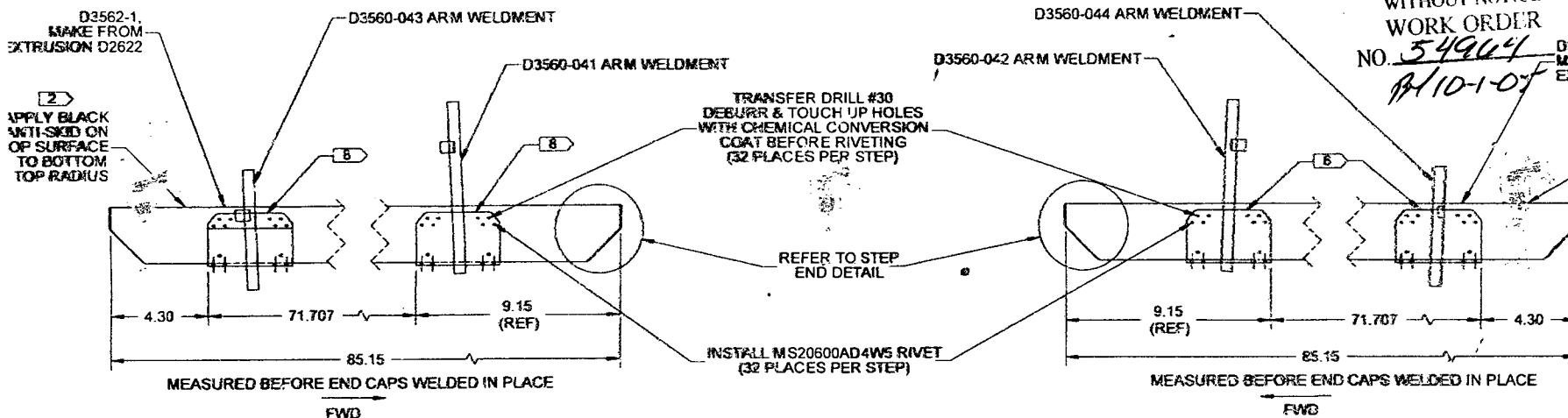
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 54964
A/10-1-05

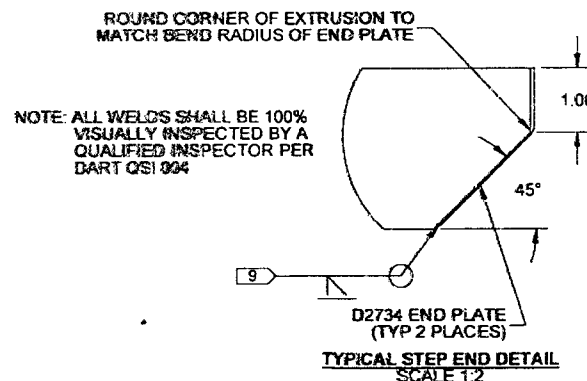
D3562-1,
MAKE FROM
EXTRUSION D2622

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS



D3562-041 LH STEP ASSEMBLY

D3562-042 RH STEP ASSEMBLY



- NOTES:
1) MATERIAL: N/A
2) FINISH:
a) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
b) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
c) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 8.79 lbs
8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2606 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D8808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	05.02.26
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SE		
CHECKED	JE	DRAWING NO. D3562	REV. E
MFG. APPR.	JP	SHEET 1 OF 1	
APPROVED	JP	TITLE STEP ASSEMBLY	SCALE 1:5
DE APPR.	JP	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	08.01.11	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION IS PERMITTED WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE LTD.	

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